

Date: Thursday, 7/19/2007 2:25:11 PM
User: Kim Johnston

Process Sheet

④

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number : 33654
Estimate Number : 10831
P.O. Number :
This Issue : 7/19/2007 S.O. No. :
Prsht Rev. : NC Part Number : D29321
First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2932 REV C
Previous Run : 33032 Drawing Revision : C
Material :
Due Date : 7/31/2007 Qty: 10 Um: Each
Written By :
Checked & Approved By : *07.07.19*
Comment : Est: B 00-06.26 New DWG rev, (mpp 2069) EC
Est Rev:C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: *4105148 B 31387*

ML 07/08/02

10

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

ML 07/08/02

10

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

ML 07/08/02

10

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ML 07/08/02

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:11 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 33654

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/08/07

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-F

07/08/09

(10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 10 5068

M-F 07/08/11

(10X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/08/13 (10X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/08/13 (10X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-13

Job Completion



C2 07/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33654
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.129	0.128	0.128	0.129		
B	0.100	0.140		0.130	0.129	0.136	0.130		
C	0.100	0.140		0.126	0.127	0.127	0.127		
D	0.210	0.230		0.222	0.223	0.224	0.223		
E	1.245	1.255		1.250	1.249	1.249	1.250		
F	1.245	1.255		1.250	1.249	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.575		
J	2.495	2.505		2.499	2.500	2.499	2.500		
K	0.257	0.262		0.259	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.239	0.238	0.238		
N	0.100	0.140		0.119	0.121	0.126	0.118		
O	0.540	0.560		0.544	0.549	0.551	0.550		
P	0.490	0.510		0.500	0.503	0.502	0.503		
Q	3.715	3.725		3.718	3.718	3.717	3.718		
R	2.470	2.510		2.496	2.494	2.493	2.493		
S	0.240	0.270		0.254	0.253	0.253	0.253		
T	0.100	0.180		0.146	0.140	0.140	0.135		
U	1.625	1.635		1.629	1.628	1.627	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.326		
X	1.125	1.145		1.136	1.138	1.137	1.136		
Y	1.565	1.585		1.576	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>ml</i>
Date:	07/08/02

Audited by:	J.F.
Date:	07/08/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33654
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.127	0.126	0.127	0.126		
B	0.100	0.140		0.130	0.129	0.130	0.128		
C	0.100	0.140		0.124	0.124	0.126	0.127		
D	0.210	0.230		0.225	0.224	0.224	0.224		
E	1.245	1.255		1.250	1.249	1.249	1.250		
F	1.245	1.255		1.250	1.249	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.120	0.121	0.121	0.121		
O	0.540	0.560		0.549	0.551	0.550	0.550		
P	0.490	0.510		0.502	0.503	0.503	0.502		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.493	2.490	2.493	2.493		
S	0.240	0.270		0.255	0.253	0.253	0.253		
T	0.100	0.180		0.140	0.135	0.137	0.138		
U	1.625	1.635		1.628	1.628	1.629	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.138	1.138	1.138	1.137		
Y	1.565	1.585		1.577	1.576	1.577	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	07/08/01

Audited by:	J.F.
Date:	07/08/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 33654
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

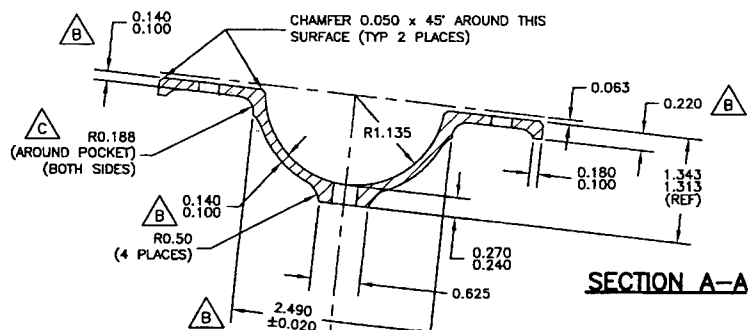
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.125				
B	0.100	0.140		0.129	0.129				
C	0.100	0.140		0.125	0.126				
D	0.210	0.230		0.224	0.224				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.510	0.510				
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.258	0.258				
L	0.312	0.317		0.314	0.314				
M	0.235	0.240		0.238	0.238				
N	0.100	0.140		0.120	0.121				
O	0.540	0.560		0.551	0.551				
P	0.490	0.510		0.502	0.502				
Q	3.715	3.725		3.718	3.718				
R	2.470	2.510		2.493	2.493				
S	0.240	0.270		0.254	0.253				
T	0.100	0.180		0.236	0.138				
U	1.625	1.635		1.628	1.628				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		0.320	0.320				
X	1.125	1.145		1.139	1.137				
Y	1.565	1.585		1.578	1.576				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

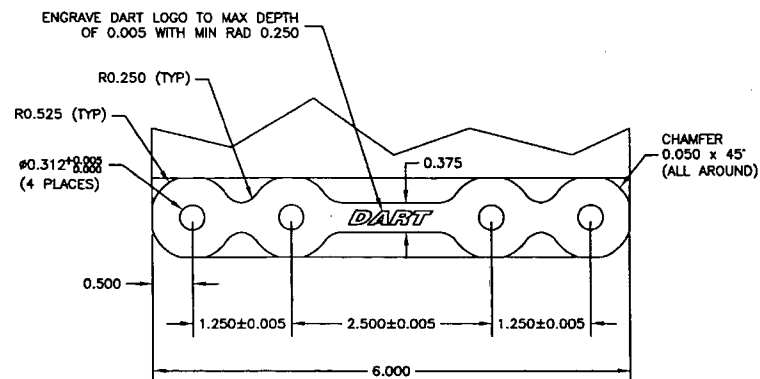
Measured by:	JNL
Date:	07/08/02

Audited by:	J.F.
Date:	07/08/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A



VIEW C-C

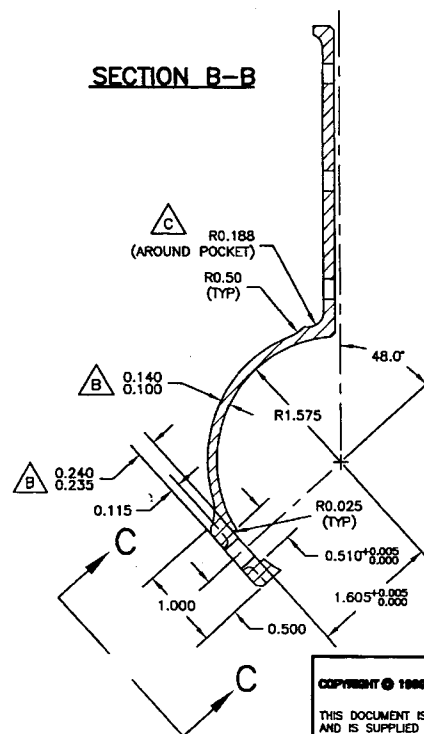
D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

SECTION B-B



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07-02-12

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